

Please cancel claims 10, 11, and 19-29, without prejudice.

1. (Amended) A method of manufacturing a magnetic material comprising:
colliding a molten alloy to a circumferential surface of a cooling roll to cool and then
solidify the molten alloy; and
producing a ribbon-shaped magnetic material having an alloy composition represented by
the formula of $R_x(Fe_{1-y}Co_y)_{100-x-z}B_z$ (where R is at least one rare-earth element, X is 10 - 15 at%,
y is 0 - 0.30, and z is 4 - 10 at%); and

expelling gas entered between the circumferential surface of the cooling roll and a puddle
of the molten alloy, wherein gas expelling means on the circumferential surface of the cooling
roll are defined by at least one groove with an average width of 0.5 – 90 μm to prevent the
molten alloy from entering the at least one groove.

3. (Amended) The method as claimed in claim 2, wherein the outer surface layer of the
cooling roll is formed of a material having a heat conductivity lower than the heat conductivity
of the structural material of the roll base at room temperature.

5. (Amended) The method as claimed in claim 2, wherein the outer surface layer of the
cooling roll is formed of a material having a heat conductivity equal to or less than $80 \text{ Wm}^{-1}\text{K}^{-1}$
at room temperature.

(34)
6. (Amended) The method as claimed in claim 2, wherein the outer surface layer of the cooling roll is formed of a material having a coefficient of thermal expansion in the range of 3.5 -18 [$\times 10^{-6} \text{K}^{-1}$] at room temperature.

10
12. (Amended) The method as claimed in claim 1, wherein the average depth of the groove is 0.5 -20 μm .

11
13. (Amended) The method as claimed in claim 1, wherein the angle defined by the longitudinal direction of the groove and the rotational direction of the cooling roll is equal to or less than 30 degrees.

(35)
12
14. (Amended) The method as claimed in claim 1, wherein the groove is formed spirally with respect to the rotation axis of the cooling roll.

(36)
13
15. (Amended) The method as claimed in claim 1, wherein the at least one groove includes a plurality of grooves which are arranged in parallel with each other through an average pitch of 0.5 – 100 μm .

(37)
14
16. (Amended) The method as claimed in claim 1, wherein the groove has openings located at the peripheral edges of the circumferential surface.

15

17. (Amended) The method as claimed in claim 1, wherein the ratio of the projected area of the groove or grooves with respect to the projected area of the circumferential surface is
B 10 - 99.5%.